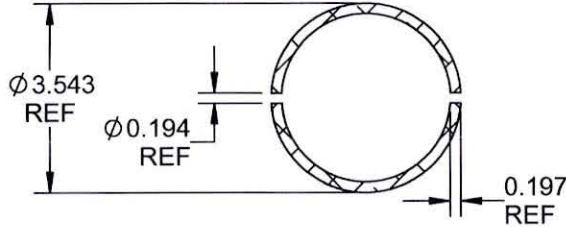
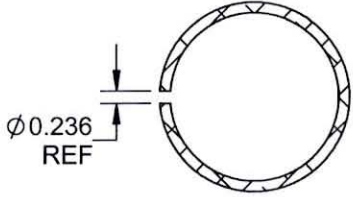


D135-1027-253 MID HEIGHT AFT CROSSTUBE



SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X

- NOTES:
- 1) MATERIAL: MANUFACTURED FROM D6027-115
STRAIGHT LENGTH = 114.08 ±0.06 (BEFORE BENDING / TRIMMING)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 20.58 lbs
 - 8) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE SHALL BE NO LARGER THAN 0.25.
 - 9) HOLES TO BE ALIGNED WITHIN 0.005 IN RELATION TO THE HOLE ON OPPOSITE SIDE OF CROSSTUBE.
 - 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
 - 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.
 - 12) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.

RELEASED
2023 MAY 01
113 ECR 448

F	ADD MISSING DIM'S 0.313 DIA, AND ADD DIM'S FOR MANUFACTURING, REASON ECR 448	SAD	22.09.21
E	REMOVE STEP HOLES, ECR 366	SAD	22.02.11
D	HOLES QTY (2) 0.236 ADDED. REASON: FOR INSTALLATION OF OPTIONAL OEM CARGO HOOK FITTING	MW	19.09.11
C	MOVED GH HOLES DIM 8.70 WAS 8.23	ZF	18.10.04
B	ADD QTY (2) 0.313 HOLES, 3.13 WAS 3.15, 12.08 WAS 12.04. REASON: DESIGN CHANGE	ML	17.05.25
A	NEW ISSUE	ML	17.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	DD	D135-1027-253	SHEET 1 OF 1
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	MID HEIGHT AFT XTUBE	NTS
DATE	22.09.21	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	